

537

452.12

DART AEROSPACE LTD		Work Order:	24/20
Description: Arm		Part Number:	D3387-2
Dwg: D3387 Rev. A		Qty:	20
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	SP	05/08/30	20
2	MV	Cut blank: 6.000" x 0.500" x 17.800" long Material: 6061-T6/T651 (QQ-A-200/8) (M6061T6B0.500x06.000) Identify for D3387-2	SL	05.09.16	20
		Batch: M18463 M17629			
3	MV	Machine as per Folio FA512 and Dwg D3387 Identify as D3387-2	JL	05.09.16	20
4	MV	C'sink Ø0.375" as per Dwg D3387	SL	05.09.24	20
5	QC2	Inspect parts as they come off the CNC machine	JL	05.09.16	20
6	QC8	Second check	J.G	05/09/25	20
7	MV	Tumble and Deburr NO sharp edges	JL	05.09.16	20
8	QC5	Inspect work to Step 7	SL	05.10.27	20
9	ST	Identify and Stock	SL	05.10.31	20
10	AC	Cost / part: 30.16	SL	05.11.01	20
11	DC	Close W/O 30.16 Inspect Level 21	SL	05/11/01	20

Rev	Date	Change	Revised By	Approved
A	05.06.10	New Issue	KJ/JLM	

RELEASED
11/05/00

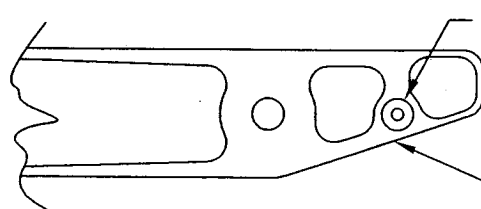
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *SD* Date: *09/11/11*

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date:



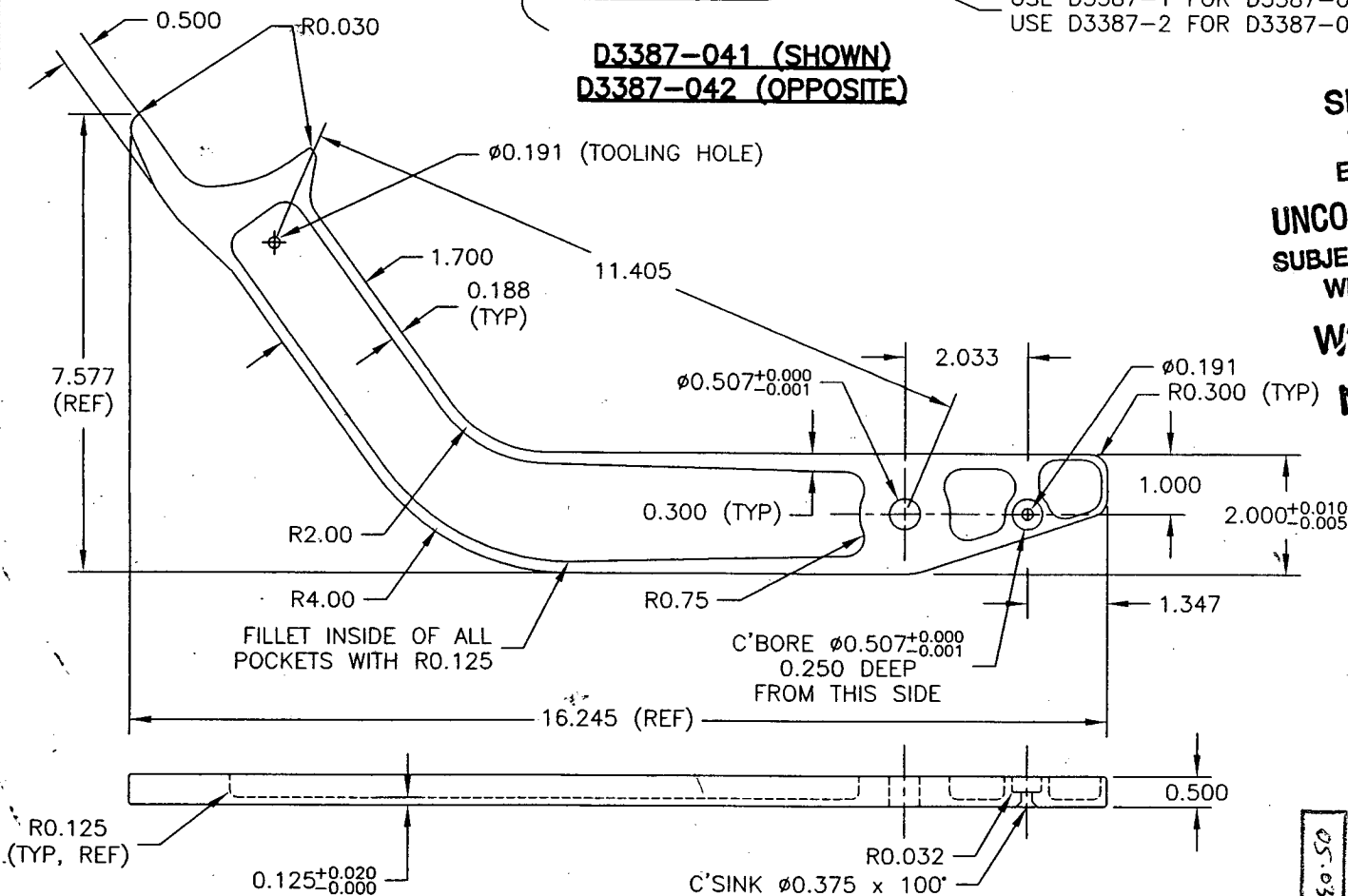
PRESS FIT D2808 SPACER (1)

USE D3387-1 FOR D3387-041
USE D3387-2 FOR D3387-042

D3387-041 (SHOWN)
D3387-042 (OPPOSITE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 24120A



D3387-1 (SHOWN)
D3387-2 (OPPOSITE)

GENERAL NOTES

- 1) MACHINE PER DRAWING FILE "D3387-A.DWG"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK (REF DART SPEC. M6061T6B0.500)
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED
05.03.11

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. A
05.01.18	D3387	SHEET 1 OF 1
	TITLE	SCALE
	ARM	1:3
	NEW ISSUE	

DART AEROSPACE LTD		Work Order:	24/20
Description: Arm		Part Number:	D3387-2
Inspection Dwg: D3387 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	.500	✓			
7.577	+/-0.010	7.577	✓			
R0.030	+/-0.010	.030	✓			
Ø0.191	+0.005/-0.000	.193	✓			
1.700	+/-0.010	1.700	✓			
0.188	+/-0.010	.188	✓			
11.405	+/-0.010	can't	measure			
Ø0.507	+0.000/-0.001	.5065	✓			
2.033	+/-0.005	2.033	✓			
R0.300	+/-0.010	.300	✓			
1.000	+/-0.005	1.001	✓			
2.000	+/-0.010	2.001	✓			
1.347	+/-0.005	1.348	✓			
0.250	+/-0.010	.247	✓			
R0.125	+/-0.010	.125	✓			
0.125	+/-0.010	.130	✓			
R0.032	+/-0.010	.032	✓			
Ø0.375 x100°	+/-0.010	.372	✓			
0.500	+/-0.010	.500	✓			
0.300	+/-0.010	.299	✓			

Measured by:	JL	Audited by:	SD	Prototype Approval:	N/A
Date:	05.09.15	Date:	05.09.15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM	

RELEASED
 05.05.23

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 25, 2005
11:07 am

Work Order No : 0024120
Project Name : D3387-2
Project For : WK537
Work Order Type : Main
Main WO Number :
House Part Number : D3387-2
Description : Arm
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 08-25-05
Est Finish Date : 09-12-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00